

Work Order ID 71970

Thursday, July 14, 2011 11:31:44 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*P*Date: *11-07-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DS19470

A

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

*8/6/15**for BG 11-9-15*

110

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: *14485*

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B *117628**11-07-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71970

Thursday, July 14, 2011 11:31:44 AM



Page 2

Item ID: D350-604-041

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Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Receive & Inspect for Damage & Mat'l Certs
Packaging

0.00

Packaging

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

_____ 8/4/13 (1)

130



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

8 11/09/13

(H) _____

140



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

_____ 8/4/15 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71970

Thursday, July 14, 2011 11:31:44 AM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 7/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 wks / 10

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

11/9/10

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/10
MF 11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 11:31:59 AM

Page 1

Work Order ID: 71970

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 7/14/2011

Required Date: 9/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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2600-6		Purchased	No			110	Each	83.0000	4	4	-		
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Camlock Stud

Location	Loc Qty	Loc Code
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ST357	83	
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117628	83	
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D350-604-041P		Purchased	No			120	Each	0.0000	1	1			
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Rear Locker Extender

D2268		Manufactured	No			140	Each	14.0000	1	1	-		
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Decal

Location	Loc Qty	Loc Code
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ST010	14	
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67420	2	
-------	---	--

69592	12	
-------	----	--

D2269		Manufactured	No			140	Each	11.0000	1	1			
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Decal

Location	Loc Qty	Loc Code
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ST010	11	
-------	----	--

67421	11	
-------	----	--

117628

11/9/13 ① 71970

69592

11/9/15 ①

67421

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14485

Purchase Order Date 7/14/2011

PO Print Date 7/14/2011

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	819 533 5788	Requisition Nbr	
Vendor Fax	819 533 3494	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D350-604-041P	Rear Locker Extender	7/25/2011 Yes	1.00 Each	FedEx Overnight	\$330.0000	\$330.00
		Special Inst:	As per DWG: D350-604-041 Rev: A B71970				
2	D350-604-041P	Rear Locker Extender	8/2/2011 Yes	1.00 Each	FedEx Overnight	\$330.0000	\$330.00
		Special Inst:	Same as above B71969				
3	D350-604-041P	Rear Locker Extender	8/8/2011 Yes	1.00 Each	FedEx Overnight	\$330.0000	\$330.00
		Special Inst:	Same as above B71968				
4	D350-604-041P	Rear Locker Extender	8/15/2011 Yes	1.00 Each	FedEx Overnight	\$330.0000	\$330.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 7/14/2011



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	40141
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
09/09/2011	23/08/2011	18460	Brigitte Golden		PO14485		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line #1 Rear Locker Extender D350-604-041P B71970 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div>No. série 34246</div> <div>No. lot 34246</div> <div>S 4/5/13</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date : Mercredi, 2011-07-06 14:17:32
Utilisateur : marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD

Numéro Job : 34246

Numéro Soumission : 3482

Numéro B.A. :

Cette fois : 2011-07-06 No. B.V. :

Prsht Rev. : NC

Prem. fois : - - Type :

Job précédente : 34245

Écrit par :

Vérifié & Approuvé par :

Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblage Dart Aerospace: D350-604-041

Nom Dessin : REAR LOCKER EXTENDER

Numéro Article : DKC134-0003

Numéro Dessin : D350-604-041 & D2273

Projet Numéro : DK-362

Révision dessin : A & D

Matériel : Derakane 470-36/411/510

Date Dûe : 2011-07-13 Qté: 1 Udm: UNITE

Process Sheet Rév.: 03 Modifier la seq. 6 Prep-general.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: 23/08/11 Sceau:



2.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-31894-2

3.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0 AC0747 Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 11-08-11 Sceau:

Date: Mercredi, 2011-07-06 14:17:32
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 34246

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

6.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003.

Date: 24/08/11 Sceau:



7.0

GEL COAT

Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 24/08/11 Sceau:



8.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-31894-1

9.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

10.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-31000-2

11.0

AMB0213

WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot:

1-28778-1

12.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:










Humidité: 49% Température: 76.5°F Heure: 10:30

Quantité: 1 Date: 25/08/11 Sceau:



Date: Mercredi, 2011-07-06 14:17:32
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: REAR LOCKER EXTENDER	
Numéro Job: 34246		Numéro Article: DKC134-0003	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
13.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: -			
14.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s) Catalyst N° DDM-9 N° de Lot: -			
15.0	FINITION	Finition Générale	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Injecter les bulles d'air selon IF134-0003 si applicable. Quantité: _____ Date: _____ Sceau: _____			
16.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager Quantité: 1 Date: 26/08/11 Sceau: 			
17.0	TRIMAGE	Trimage	
			
Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs Selon IF 134-0002. Faire le sablage si nécessaire. Quantité: 1 Date: 29/08/11 Sceau: 			
18.0	AAC1021	Dupont Primer N° 7704S	
Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-31117-2			
19.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-31394-2			

Date: Mercredi, 2011-07-06 14:17:32

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 34246

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

20.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1

Date: 9/09/11

Sceau:



N° fiche de Mélange: 1/4

21.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-31768-1

22.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6607-1

23.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasquer la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1

Date: 9/09/11

Sceau:



24.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 34246

N° de Fabrication: 9-09-11

Quantité: 1

Date: 9-09-11

Sceau:



25.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Mercredi, 2011-07-06 14:17:32

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 34246

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date: 09 SEP. 11

Sceau:



bb

26.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date: 9/09/11

Sceau:

